

Thursday, April 20, 2017 2:02:16 PM

Page 1

Item ID:	D4009-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Bonding* Braid				Stop	*NS2*
Start Date:	4/20/2017	Start Qty: 4.00	*4*	Cust Item ID:		
Required Date:	4/21/2017	Req'd Qty: 4.00	*4*	Customer:		
Reference:	(P.A.)SCHEDULED/S					

Approvals:	Process Plan: <u>21</u>	Date: <u>APR 25 2017</u>	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: <u>9-89</u>	Date: _____	SPC (Y/N): _____	Date: _____			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4009	A ✓								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.96				4x			17/04/21
Packaging									
120		0.00							
120									
Small Fab	Memo	0.96				4x			17/04/21
Small Fab	Assemble as per dwg D4009								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.08				4			
Quality Control									

DAS 36 9-89

DAS 36 9-89

DAS 38 9-89

APR 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 160075

Thursday, April 20, 2017 2:02:16 PM

160075

Page 2

Item ID: D4009-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bonding Braid
Start Date: 4/20/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/21/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>Spot</u> Memo	0.00 0.04				<u>4</u>	<u>DAS 6 99</u>	<u>APR 21 2017</u>	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40						<u>17/4/26</u> <u>JD</u>	<u>DAS 21 9-89</u> <u>APR 24 2017</u>

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By Lead hand / Supervisor Approval Verification		
					QC / QA Coordinator Approval				

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	☐ OTHER : _____					
☐ Misidentified	☐ Past Due						

Picklist Print

Thursday, April 20, 2017 2:02:16 PM

Page 1

Work Order ID: 160075

160075

Parent Item: D4009-041

D4009-041

Parent Item Name: Bonding Braid

Start Date: 4/20/2017

Required Date: 4/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.02.02 new issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4009-1 *D4009-1* Terminal End		Manufactured	No			110	Each	22.0000	2	8		17/04/21	68-6 93 DAS
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST070				22					
				152944				22		8			68-6 93 DAS
D4009-3 *D4009-3* Ground Strap		Manufactured	No			110	Each	16.0000	1	4		17/04/21	68-6 93 DAS
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				5					
				157521				5					
				ST070				11					
				112347				1		3			68-6 93 SVC
				154559				5					
				159027				5					
D4009-5 *D4009-5* Ground Strap		Manufactured	No			110	Each	14.0000	1	4		17/04/21	68-6 93 SVC
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				5					
				157553				5					
				ST071				9					
				115076				4		4			
				154562				5					

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, April 20, 2017 2:02:16 PM

Page 2

Work Order ID: 160075

160075

Parent Item: D4009-041

D4009-041

Parent Item Name: Bonding Braid

Start Date: 4/20/2017

Required Date: 4/21/2017

Start Qty: 4.00

Required Qty: 4.00

D4009-7

Manufactured No

110

Each

43.0000

1

4

D4009-7

**

Tab

Location

Loc Qty

Loc Code

ST071

43

121538

43

D4009-9

Manufactured No

110

Each

22.0000

1

4

D4009-9

**

Receptacle

Location

Loc Qty

Loc Code

ST071

22

113166

22

17/04/21
DAS
36
9-89

17/04/21
S
36
9-89

4

4

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WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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